

Listing of Claims:

This listing of claims reflects all claim amendments and replaces all prior versions, and listings, of claims in the application. Material to be inserted is in **underline**, and material to be deleted is in ~~strikeout~~ or (if the deletion is of five or fewer consecutive characters or would be difficult to see) in double brackets [[]]. Any cancellations are without prejudice.

1-13. (Canceled)

14. (New) A process for bending workpieces with at least one bending device and at least one robot, comprising picking up the workpiece to be shaped with the at least one robot and feeding it to the at least one bending device for shaping, the at least one bending device being arranged in a positionally fixed manner with respect to a surface and the at least one robot arm feeding continuously or batch-wise the workpiece for shaping to the at least one bending device or its bending heads, and the robot gripping the workpiece while feeding it into the at least one bending device during bending and, for further bending, feeding it anew to the at least one bending device and rotating the workpiece radially.

15. (New) The process according to claim 1, wherein the workpieces comprise at least one workpiece selected from pipes, wires, bars, semi-finished products, and sheet metal.

16. (New) The process according to claim 1, wherein the shaping comprises bending.

17. (New) The process according to claim 14, wherein the robot continuously feeds the workpiece to the at least one bending device.
18. (New) The process according to claim 14, wherein a robot arm picks up the workpiece and directly feeds it to the at least one bending device or directly to its bending head.
19. (New) The process according to claim 18, wherein the robot arm comprises at least one gripping device of the at least one robot.
20. (New) The process according to claim 18, wherein the robot arm feeds the workpiece batch-wise to the at least one bending device and the bending device shapes the workpiece at corresponding bending regions, and wherein during the shaping the robot arm picks up the workpiece by gripping it at any different place, including but not limited to in a finished region, to further feed the workpiece into the at least one bending device.
21. (New) The process according to claim 14, wherein the at least one robot picks up the workpiece and feeds it to a plurality of bending devices for shaping different radii, bends, and/or angles, the workpiece being radially rotatable in the gripping device.
22. (New) The process according to claim 21, comprising roller bending heads, right-hand/left-hand bending heads, and bending devices with mandrel devices, folding devices or the like that are used as bending devices.

23. (New) The process according to claim 14, wherein the at least one robot removes the workpiece from a supply bin, feeds it to the bending device for shaping or bending and subsequent to bending to a storage area for further machining, said robot again picking up a workpiece to be shaped or bent from the supply bin.
24. (New) The process according to claim 14, wherein subsequent to the shaping or bending of a workpiece, said workpiece is guided by the at least one robot along a measuring device so as to detect the shapes or bends as a desired value, a process inspection being conducted upon comparison of said desired value with a stored and selected desired value and optionally a re-shaping or re-bending being effected by means of the robot re-feeding the workpiece to the at least one bending device.
25. (New) The process according to claim 24, wherein subsequent to re-bending or re-shaping, the workpiece is re-fed, by means of the robot, to the measuring device and only after there is agreement between the desired value and measured value or with the predetermined tolerance ranges is the workpiece fed to the storage area or to further machining.
26. (New) The process according to claim 14, wherein the workpiece is delivered to another robot, a conveyor belt, a machine, a supply bin or the like as a storage area or for further machining.

27. (New) The process according to claim 14, wherein the robot picks up the workpiece and directly feeds said workpiece in selectable regions that are to be shaped to the bending device or its bending heads, removes said workpiece subsequent to shaping, and feeds other regions or end parts of the workpiece for further machining or shaping, after complete processing of the workpiece the robot supplies the workpiece for delivery or additional processing.
28. (New) The process according to claim 14, wherein the bending unit can be manually and/or automatically moved with respect to the position of the robot.
29. (New) The process according to claim 14, wherein the bending unit comprises a bending device.
30. (New) The process according to claim 29, wherein the bending unit can automatically or with a cross slide travel a linear system in a selectable direction or along a selectable guide system with respect to the position of the robot, the corresponding position coordinates being transferred to the robot.
31. (New) A process for bending workpieces with at least one bending device and at least one robot arm, the at least one bending device being arranged in a positionally fixed manner with respect to a surface, the process comprising picking up the workpiece to be shaped with the at least one robot arm; feeding the workpiece to the at least one bending device for shaping, wherein the at least one robot arm grips the workpiece while feeding

it into the at least one bending device during bending; and feeding the workpiece again to the at least one bending device with the at least one robot arm for further bending.

32. (New) The process of claim 31, further comprising rotating the workpiece radially with the at least one robot arm.
33. (New) The process of claim 31, wherein the at least one robot arm feeds the workpiece to the at least one bending device in at least one of a batch-wise manner and a continuous manner.